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United States
Department of
Agriculture

Food Safety
and Inspection
Service

HACCP-5

March 1994

Generic HACCP* Model for Swine Slaughter

*Hazard Analysis
and Critical Control
Point (HACCP)

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Introduction

HACCP Generic Model for Swine Slaughter

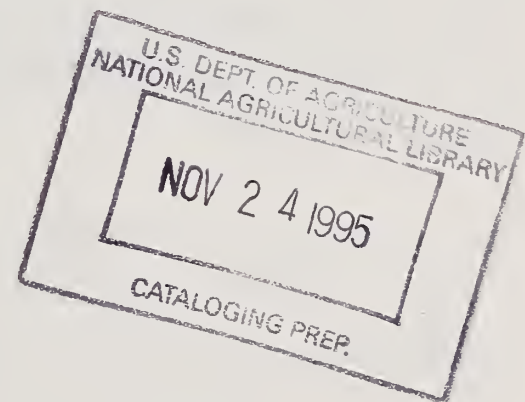
Hazard Analysis and Critical Control Points (HACCP) is a system of process control. It is designed to prevent the occurrence of problems by ensuring that controls are applied at any point in a food production system where hazardous or critical situations could occur. Hazards could include microbiological, chemical, or physical adulteration of food products.

In late May 1993, U.S. Department of Agriculture (USDA) Secretary Mike Espy directed USDA's Food Safety and Inspection Service (FSIS) to provide him with a plan for implementing mandatory HACCP in the nation's meat and poultry establishments. The Secretary recognized that such a system, which has been under study by FSIS, was a necessary building block of the inspection system of the future.

In workshops held in 1991 and 1992, five generic HACCP models were developed and are being published for public information. The models should be useful for companies developing individualized plans.

The five generic HACCP models are:

- Refrigerated Foods
- Cooked Sausage
- Poultry Slaughter
- Fresh Ground Beef
- Swine Slaughter



The workshop for Pork Slaughter (Market Hogs) was held in Minneapolis, Minnesota, from March 31-April 2, 1992. Over 40 technical and subject matter experts from industry and government collaborated in the generic model development. Participants identified 10 critical control points (CCP's) for pork slaughter, including: receiving/holding, scalding, dehairing, trimming, neck breaker/head dropping/brisket opening, splitting, trim rail/final rail inspection for trimming, cooler, operational sanitation, and pre-op sanitation. This is the generic HACCP model for Pork Slaughter (Market Hogs).

Information on the other four workshops follows:

The workshop for Cooked Sausage was held in Fort Worth, Texas, from May 21-23, 1991. Over 40 technical and subject matter experts from industry and government collaborated in the generic model development. Participants identified 9 critical control points (CCP's) for cooked sausage, including: receiving, meat preparation, non-meat ingredient combining, pre-blend/formulation/staging (re-work), cooking/smoking, chilling/storage, peeling, packaging, and storage. This is the generic HACCP model for Cooked Sausage.

The workshop for Refrigerated Foods was held in Baltimore, Maryland, from February 26-28, 1991. Over 40 technical and subject matter experts from industry and government collaborated in the generic model development. Participants identified 14 critical control points (CCP's) for refrigerated foods, including: preparation, cooking, chilling, assembling components into packages, flushing with gas atmosphere, package inspection, labeling and code dating, chilling, and storage. This is the generic HACCP model for Refrigerated Foods.

The workshop for Poultry Slaughter was held in Atlanta, Georgia, from August 27-29, 1991. Over 40 technical and subject matter experts from industry and government collaborated in the generic model development. Participants identified 10 critical control points (CCP's) for poultry slaughter, including: receiving, scalding, venting/opening, eviscerating, offline procedures, neck and giblet chilling, final wash, carcass chilling, packaging/labeling, and storage/distribution. This is the generic HACCP model for Poultry Slaughter.

The workshop for Fresh Ground Beef was held in Phoenix, Arizona, from December 3-5, 1991. Over 40 technical and subject matter experts from industry and government collaborated in the generic model development. Participants identified 10 critical control points (CCP's) for fresh ground beef, including: sanitation, receiving, storage, assembly, pre-weigh/pre-grind (re-work), final grind, packaging/labeling, storage, and shipping. This is the generic HACCP model for Fresh Ground Beef.

PRODUCT CATEGORY DESCRIPTION

PRODUCT CATEGORY : PORK SLAUGHTER MARKET HOGS

WORKSHOP LOCATION : MINNEAPOLIS, MN

THE FOLLOWING QUESTIONS NEED TO BE ANSWERED WHEN DEVELOPING THE PRODUCT CATEGORY DESCRIPTION:

- | | |
|---|--|
| 1. COMMON NAME? | PORK SLAUGHTER MARKET HOGS |
| 2. HOW IS IT TO BE USED? | WHOLE CARCASS FOR FURTHER PROCESSING |
| 3. STORAGE TEMPERATURE? | TIME/TEMPERATURE TO LIMIT MICROORGANISM GROWTH DURING THE CHILLING PROCESS TO BE DETERMINED BY EACH PROCESSOR |
| 4. LABELING/BRANDING? | LEGIBLE BRAND |
| 5. IS SPECIAL DISTRIBUTION CONTROL NEEDED? | N/A |

HAZARD ANALYSIS/PREVENTIVE MEASURES**PRODUCT CATEGORY : PORK SLAUGHTER (MARKET HOGS)****WORKSHOP LOCATION : MINNEAPOLIS, MN**

Process Step	Chemical Physical Biological Hazards	Preventive Measures	CCP
RECEIVING/HOLDING	CHEMICAL SULFAMETHAZINE, OTHER ANTIBIOTICS & RESIDUES	(REFER TO REMOVE BLADDER STEP)	NO
	PHYSICAL EAR TAGS; NOSE TAGS	(REFER TO TRIMMING STEP)	NO
	BIOLOGICAL PATHOLOGICAL CONDITIONS		NO
STUNNING	NONE		
SHACKLING	NONE		
STICKING/BLEEDING	NONE		
SCALDING	CHEMICAL ANTI-FOAMING AGENTS	IDENTIFICATION; CONCENTRATION	YES
	BIOLOGICAL MICRO	TIME AND TEMPERATURE	YES
DEHAIRING	BIOLOGICAL MICRO	RINSE AND EQUIPMENT	YES
GAMBRELLING	NONE		
SINGEING/ POLISHING/ WASH	BIOLOGICAL MICRO	RINSE AND EQUIPMENT	YES
SHAVING	NONE		
PRE-EVISCERATION WASH	NONE		

NOTE: THIS IS A DOCUMENT DEVELOPED FOR THE HACCP SPECIAL TEAM. IT HAS BEEN USED AS A TRAINING TOOL IN THE METHODOLOGY USED TO ASSIST INDUSTRY IN DEVELOPING A WORKSHOP HACCP MODEL.

HAZARD ANALYSIS/PREVENTIVE MEASURES**PRODUCT CATEGORY : PORK SLAUGHTER (MARKET HOGS)****WORKSHOP LOCATION : MINNEAPOLIS, MN**

Process Step	Chemical Physical Biological Hazards	Preventive Measures	CCP
TRIMMING	PHYSICAL EAR TAGS; NOSE TAGS	REMOVAL	YES
	BIOLOGICAL MICRO	REMOVAL OF VISUAL CONTAMINANTS/ PUNCTURE IN SKIN	YES
NECK BREAKER	BIOLOGICAL MICRO	SANITIZING OF NECK BREAKER AFTER EACH CARCASS	YES
HEAD DROPPING	BIOLOGICAL MICRO	SANITIZING OF KNIVES AFTER EACH HEAD DROP	YES
BRISKET OPENING	BIOLOGICAL MICRO	SANITIZING OF SAWS OR SPLITTERS AFTER EACH CARCASS	YES
REMOVE BLADDER & REPRODUCTIVE ORGANS	BIOLOGICAL MICRO	SANITARY DRESSING PROCEDURES; STERILIZING OF EQUIPMENT AFTER EACH CARCASS	YES
SPLIT AITCH BONE/ BUNG DROPPING	BIOLOGICAL MICRO	SANITARY DRESSING PROCEDURES	YES
EVISCERATION	BIOLOGICAL MICRO	REMOVAL OF DEFECTS	YES
RAIL FOR ADDITIONAL TRIMMING	BIOLOGICAL MICRO	REMOVAL OF DEFECTS	YES
SPLITTING	BIOLOGICAL MICRO	SANITIZING OF EQUIPMENT AFTER EACH INCIDENCE OF CONTAMINATION	YES

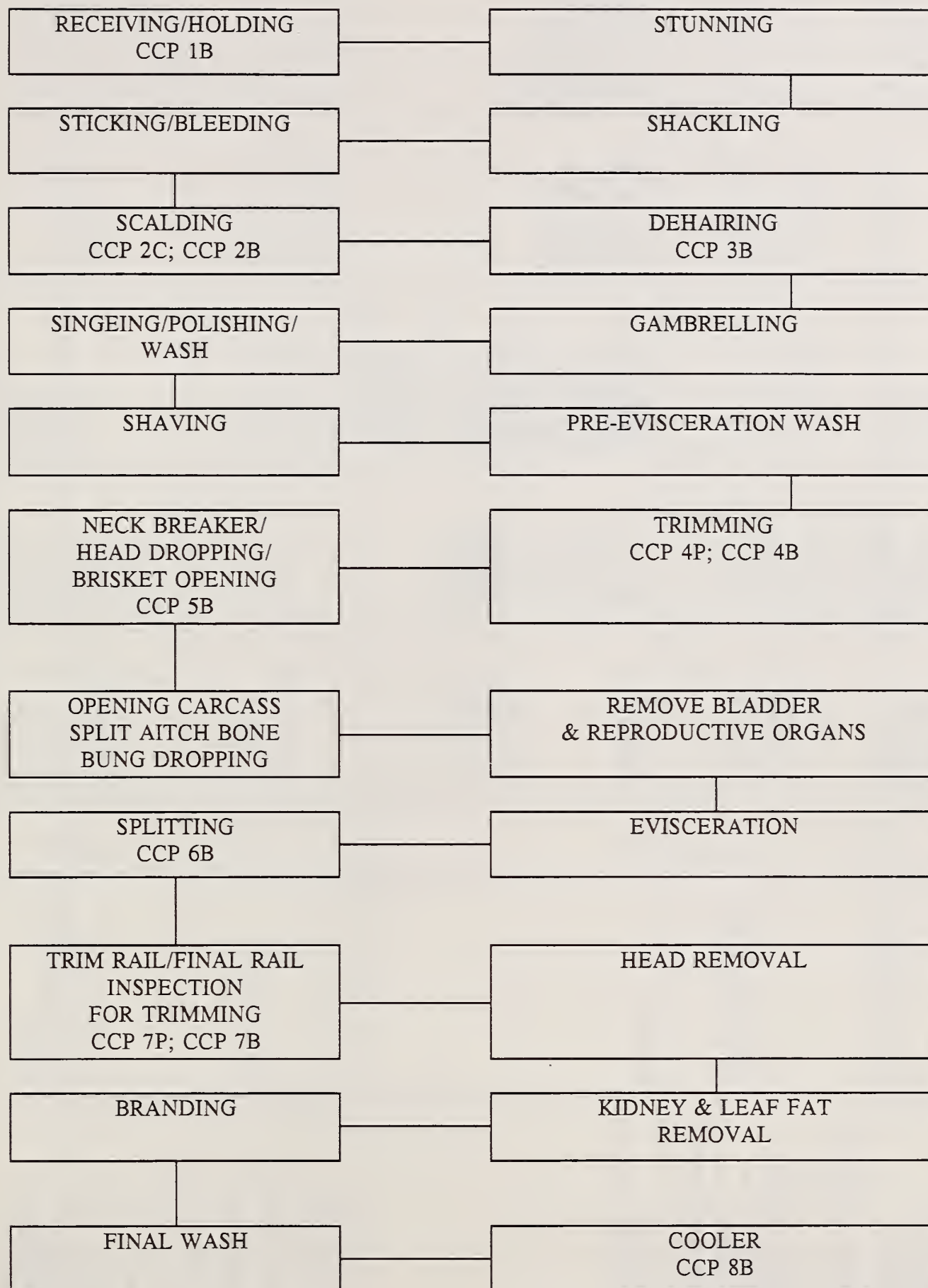
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HAZARD ANALYSIS/PREVENTIVE MEASURES**PRODUCT CATEGORY : PORK SLAUGHTER (MARKET HOGS)****WORKSHOP LOCATION : MINNEAPOLIS, MN**

Process Step	Chemical Physical Biological Hazards	Preventive Measures	CCP
TRIMMING	BIOLOGICAL MICRO	REMOVAL OF DEFECTS	YES
HEAD REMOVAL	NONE		
KIDNEY & LEAF FAT REMOVAL	NONE		
BRANDING	NONE		
FINAL WASH	BIOLOGICAL MICRO		NO
COOLER	BIOLOGICAL MICRO	COOLER TIME AND TEMPERATURE; CONTROL PROPER AIRFLOW	YES

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PORK SLAUGHTER MARKET HOGS



OPERATIONAL SANITATION CCP 9B

PRE-OP SANITATION CCP 10C; 10B

REVISED 04/02/92

HAZARD ANALYSIS/PREVENTIVE MEASURES									
PRODUCT CATEGORY :		PORK SLAUGHTER MARKET HOGS							
WORKSHOP LOCATION :		MINNEAPOLIS, MN							
Process Step	Chemical Physical Biological Hazards	Preventive Measures	CCP	Critical Limits for Preventive Measures	Monitoring Procedures/ Frequency/ Person Responsible	Corrective/ Preventive Action/ Person Responsible	HACCP Records	Verification Procedure/ Person Responsible	
RECEIVING/ HOLDING	CHEMICAL - PESTICIDES & ANTIBIOTIC RESIDUES;		NO						
	PHYSICAL-HYPODERMIC NEEDLES; BB SHOT		NO						
	PHYSICAL-EAR TAGS & NOSE RINGS	SEE TRIMMING STATION PRIOR TO HEAD DROPPING	NO						
	BIOLOGICAL-MICROBIAL CONTAMINATION;		NO						
	BIOLOGICAL-PATHOLOGICAL DEFECTS	ANTEMORTEM	CCP 1B	NO VISIBLE ABNORMALITIES	VISUAL INSPECTION OF ALL HOGS. BY DESIGNATED, QUALIFIED LIVESTOCK PERSONNEL. SORTED HCG INFORMATION WILL BE DOCUMENTED.	CONTROL AND CORRECT AT HEAD INSPECTION, VISCERA INSPECTION OR FINAL RAIL. SLAUGHTER ABNORMALS IN A LOT BY THEMSELVES. FEEDBACK-RETRAIN. DOCUMENT ALL INFORMATION.	MAINTAIN LOT CARD/PLANT SORT RECORDS DAILY INCLUDING DEVIATIONS AND CORRECTIVE ACTIONS.	PLANT DESIGNATED HACCP COORDINATOR TO VERIFY RECORDS AND PROCEDURES. VERIFICATION PROCEDURES TO BE DETERMINED BY PLANT.	
STUNNING	CHEMICAL - NONE								
	PHYSICAL - NONE								
	BIOLOGICAL - NONE								
	CHEMICAL - NONE								
	PHYSICAL - NONE								
SHACKLING	BIOLOGICAL - NONE								
	CHEMICAL - NONE								
	PHYSICAL - NONE								
	BIOLOGICAL - NONE								
	CHEMICAL - NONE								
STICKING/ BLEEDING	PHYSICAL - NONE								
	BIOLOGICAL - MICROBIOLOGICAL CONTAMINATION	TRIMMING PRIOR TO NECK BREAKER	NO						

NOTE: THIS IS A DOCUMENT DEVELOPED AT THE INDUSTRY HACCP WORKSHOP FOR PORK SLAUGHTER (MARKET HOGS). IT DEMONSTRATES THE METHODOLOGY USED TO DEVELOP THE GENERIC INDUSTRY HACCP MODEL.

March 31 - April 2, 1992

HAZARD ANALYSIS/PREVENTIVE MEASURES									
PRODUCT CATEGORY :		PORK SLAUGHTER MARKET HOGS							
WORKSHOP LOCATION :		MINNEAPOLIS, MN							
Process Step	Chemical Physical Biological Hazards	Preventive Measures	CCP	Critical Limits for Preventive Measures	Monitoring Procedures/Frequency/Person Responsible	Corrective/Preventive Action/Person Responsible	HACCP Records	Verification Procedure/Person Responsible	
SCALDING	CHEMICAL-CHEMICAL ADDITIVES	EMPLOYEE TRAINING 							

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March 31 - April 2, 1992

HAZARD ANALYSIS/PREVENTIVE MEASURES PRODUCT CATEGORY : PORK SLAUGHTER MARKET HOGS WORKSHOP LOCATION : MINNEAPOLIS, MN								
Process Step	Chemical Physical Biological Hazards	Preventive Measures	CCP	Critical Limits for Preventive Measures	Monitoring Procedures/ Frequency/ Person Responsible	Corrective/ Preventive Action/ Person Responsible	HACCP Records	Verification Procedure/ Person Responsible
	BIOLOGICAL - MICROBIOLOGICAL CONTAMINATION	TIME/TEMPERATURE	CCP 3B	TIME/TEMPERATURE DETERMINED BY PLANT SPECIFIC TESTING RESULTS TO REMOVE VISIBLE HAIR TO AN ACCEPTABLE LEVEL WITHOUT BREAKING SKIN	PLANT SPECIFIC MONITORING BY A TRAINED AND QUALIFIED PLANT INDIVIDUAL. RECORD OBSERVATIONS ON TIME/TEMPERATURE ON CHART OR HACCP LOG	EVALUATE THE CAUSE AND/OR SIGNIFICANCE OF THE DEVIATION. QUALIFIED/TRAINED PLANT INDIVIDUAL WILL TAKE NECESSARY ACTION TO CORRECT OR PREVENT UNACCEPTABLE CONDITIONS. HOLD UNACCEPTABLE CARCASSES FOR CORRECTIVE ACTION. CORRECTIVE ACTION RECORDED ON HACCP DEVIATION LOG.	TIME/TEMPERATURE RECORDING CHART OR LOG; HACCP/ DEVIATION LOG; HOLD TAG; RECORDS ON FILE AND AVAILABLE FOR REVIEW.	SLAUGHTER FLOOR SUPERVISOR OR DESIGNEE WILL VERIFY DAILY. QC/PLANT SUPERVISOR WILL AUDIT HACCP RECORDS AT FREQUENCY DETERMINED BY PLANT SPECIFIC PLAN. VERIFICATIONS RECORDED ON AUDIT RECORD.
GAMBRELLING	CHEMICAL - NONE PHYSICAL - NONE BIOLOGICAL - NONE CHEMICAL - NONE PHYSICAL - NONE	PROPER MAINTENANCE	CCP 3B	DEHAIRER MAINTAINED AT AN ACCEPTABLE LEVEL CONSISTENT WITH REMOVAL OF VISIBLE HAIR WITHOUT BREAKING SKIN	PLANT SPECIFIC MONITORING BY A TRAINED AND QUALIFIED PLANT INDIVIDUAL. RECORD OBSERVATIONS ON MAINTENANCE LOG.	EVALUATE THE CAUSE AND/OR SIGNIFICANCE OF THE DEVIATION. QUALIFIED/TRAINED PLANT INDIVIDUAL WILL TAKE NECESSARY ACTION TO CORRECT OR PREVENT UNACCEPTABLE CONDITIONS. HOLD UNACCEPTABLE CARCASSES FOR CORRECTIVE ACTION. CORRECTIVE ACTION RECORDED ON HACCP DEVIATION LOG.	MAINTENANCE RECORD; HACCP/ DEVIATION LOG; HOLD TAG; RECORDS ON FILE AND AVAILABLE FOR REVIEW.	MAINTENANCE SUPERVISOR OR DESIGNEE WILL VERIFY AS NEEDED. QC/PLANT SUPERVISOR WILL AUDIT HACCP RECORDS AT FREQUENCY DETERMINED BY PLANT SPECIFIC PLAN. VERIFICATIONS RECORDED ON AUDIT RECORD.
SINGEING/ POLISHING/ WASH	CHEMICAL - NONE PHYSICAL - NONE BIOLOGICAL - NONE							

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March 31 - April 2, 1992

HAZARD ANALYSIS/PREVENTIVE MEASURES								
PRODUCT CATEGORY :		PORK SLAUGHTER MARKET HOGS						
WORKSHOP LOCATION :		MINNEAPOLIS, MN						
Process Step	Chemical Physical Biological Hazards	Preventive Measures	CCP	Critical Limits for Preventive Measures	Monitoring Procedures/ Frequency/ Person Responsible	Corrective/ Preventive Action/ Person Responsible	HACCP Records	Verification Procedure/ Person Responsible
SHAVING	BIOLOGICAL - NONE							
	CHEMICAL - NONE							
	PHYSICAL - NONE							
	BIOLOGICAL - NONE							
PRE-EVISCKERATION WASH	CHEMICAL - NONE							
	PHYSICAL - NONE							
	BIOLOGICAL - NONE							
	CHEMICAL - NONE							
TRIMMING	PHYSICAL-EAR TAGS & NOSE RINGS	REMOVAL	CCP 4P	TOTAL REMOVAL OF ALL EAR TAGS AND NOSE RINGS	MONITORING WITH SUFFICIENT FREQUENCY BY DESIGNATED PLANT EMPLOYEE. RECORD OBSERVATIONS ON HACCP LOG.	EVALUATE CAUSE AND ENSURE COMPLETE REMOVAL. HOLD AND RETRIM PRODUCT. RETRAIN EMPLOYEE. CORRECTIVE ACTION RECORDED ON HACCP DEVIATION LOG.	HACCP/DEVIATION LOG; HOLD TAG; RECORDS ON FILE AND AVAILABLE FOR REVIEW.	SLAUGHTER FLOOR SUPERVISOR OR DESIGNEE WILL VERIFY DAILY. QC/PLANT SUPERVISOR WILL AUDIT HACCP RECORDS AT FREQUENCY DETERMINED BY PLANT SPECIFIC PLAN. VERIFICATIONS RECORDED ON AUDIT RECORD.
	BIOLOGICAL - MICROBIOLOGICAL CONTAMINATION	REMOVAL OF STICK WOUND	CCP 4B	NO VISIBLE STICK WOUND RELATED DEFECTS	MONITORING WITH SUFFICIENT FREQUENCY BY DESIGNATED PLANT EMPLOYEE. RECORD OBSERVATIONS ON HACCP LOG.	EVALUATE CAUSE AND ENSURE COMPLETE REMOVAL. HOLD AND RETRIM PRODUCT. RETRAIN EMPLOYEE. CORRECTIVE ACTION RECORDED ON HACCP DEVIATION LOG.	HACCP/DEVIATION LOG; HOLD TAG; RECORDS ON FILE AND AVAILABLE FOR REVIEW.	SLAUGHTER FLOOR SUPERVISOR OR DESIGNEE WILL VERIFY DAILY. QC/PLANT SUPERVISOR WILL AUDIT HACCP RECORDS AT FREQUENCY DETERMINED BY PLANT SPECIFIC PLAN. VERIFICATIONS RECORDED ON AUDIT RECORD.
	CHEMICAL - NONE							
	PHYSICAL - NONE							
NECK BREAKER/ HEAD DROPPING/ BRISKET OPENING								

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March 31 - April 2, 1992

HAZARD ANALYSIS/PREVENTIVE MEASURES								
PRODUCT CATEGORY :		PORK SLAUGHTER MARKET HOGS						
WORKSHOP LOCATION :		MINNEAPOLIS, MN						
Process Step	Chemical Physical Biological Hazards	Preventive Measures	CCP	Critical Limits for Preventive Measures	Monitoring Procedures/ Frequency/ Person Responsible	Corrective/ Preventive Action/ Person Responsible	HACCP Records	Verification Procedure/ Person Responsible
	BIOLOGICAL- MICROBIOLOGICAL CONTAMINATION	SANITIZING EQUIPMENT BETWEEN EACH CARCASS	CCP 5B	SANITIZING EQUIPMENT BETWEEN EACH CARCASS; 180 o F. MINIMUM H2O OR OTHER APPROVED METHOD OF SANITIZING	PLANT SPECIFIC PROGRAM TO MEET CRITICAL LIMITS (A)OPERATOR OBSERVATION (B) TEMPERATURE OR CHEMICAL CHECK FREQUENCY AND RESPONSIBLE PERSON TO BE DETERMINED BY PLANT. RESPONSIBLE PERSON TO RECORD OBSERVATIONS AND INITIAL RECORD.	IMMEDIATE CORRECTIVE ACTION TO INSURE CRITICAL LIMITS ARE MET TO INCLUDE: (A)INSTRUCTING EMPLOYEE (B)TEMPERATURE AND/OR CHEMICAL REQUIREMENT IS MET.	CCP LOG. LOG TO BE MAINTAINED FOR TIME PERIOD SPECIFIED BY PLANT.	PLANT MANAGEMENT TO REVIEW RECORDS AND VERIFY HACCP PROCEDURES/ACCURACY OF INSTRUMENTS; FREQUENCY TO BE DETERMINED BY PLANT
OPENING CARCASS/ SPLIT AITCH BONE/ BUNG DROPPING	CHEMICAL -NONE							
	PHYSICAL -NONE							
	BIOLOGICAL - MICROBIOLOGICAL CONTAMINATION	OPERATIONAL SANITATION						
REMOVE BLADDER & REPRODUCTIVE ORGANS	CHEMICAL -NONE							
	PHYSICAL -NONE							
	BIOLOGICAL - MICROBIOLOGICAL CONTAMINATION	OPERATIONAL SANITATION						
EVisCERATION	CHEMICAL -NONE							
	PHYSICAL -NONE							
	BIOLOGICAL - MICROBIOLOGICAL CONTAMINATION	OPERATIONAL SANITATION						

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March 31 - April 2, 1992



HAZARD ANALYSIS/PREVENTIVE MEASURES								
PRODUCT CATEGORY :		PORK SLAUGHTER MARKET HOGS						
WORKSHOP LOCATION :		MINNEAPOLIS, MN						
Process Step	Chemical Physical Biological Hazards	Preventive Measures	CCP	Critical Limits for Preventive Measures	Monitoring Procedures/ Frequency/ Person Responsible	Corrective/ Preventive Action/ Person Responsible	HACCP Records	Verification Procedure/ Person Responsible
SPLITTING	CHEMICAL-NONE							
	PHYSICAL-NONE						/	
	BIOLOGICAL-MICROBIOLOGICAL CONTAMINATION	SANITIZING AFTER EACH CARCASS OR OPERATIONAL SANITATION	CCP 6B	WATER TEMPERATURE MAINTAINED \geq 180 o F. OR OTHER APPROVED METHODS. IF SPLIT PRIOR TO VISCERA INSPECTION; SANITIZE AFTER EACH CARCASS. IF SPLIT AFTER VISCERA INSPECTION: SANITIZE EACH OCCURRENCE OF CONTAMINATION	PLANT SPECIFIC PROGRAM TO MEET CRITICAL LIMITS (A)OPERATOR OBSERVATION (B) TEMPERATURE OR CHEMICAL CHECK FREQUENCY AND RESPONSIBLE PERSON TO BE DETERMINED BY PLANT. RESPONSIBLE PERSON TO RECORD OBSERVATIONS AND INITIAL RECORD.	NOTIFY APPROPRIATE PLANT MANAGEMENT AND TAKE APPROPRIATE CORRECTIVE ACTION; EMPLOYEE TRAINING BY DESIGNATED PLANT MANAGEMENT EQUIPMENT CALIBRATION.	DAILY DOCUMENTATION LOG MAINTAINED AND SIGNED BY DESIGNATED PLANT EMPLOYEE; LOCATION OF LOG IS PLANT SPECIFIC	PERIODIC AUDIT BY DESIGNATED HACCP TEAM PERSONNEL FOR ACCURACY AND COMPLETENESS OF DOCUMENTATION.
TRIM RAIL/RETAIN RAIL/FINAL RAIL	CHEMICAL-NONE							
	PHYSICAL-DEADLOCKS	REMOVAL	CCP 7P	ZERO TOLERANCE	MONITORING WITH SUFFICIENT FREQUENCY BY DESIGNATED PLANT EMPLOYEE. RECORD OBSERVATIONS ON HACCP LOG.	NOTIFY APPROPRIATE PERSONNEL AND TAKE APPROPRIATE CORRECTIVE ACTION; EMPLOYEE TRAINING; DESIGNATED PLANT MANAGEMENT	DAILY DOCUMENTATION LOG MAINTAINED AND SIGNED BY DESIGNATED PLANT EMPLOYEE; LOCATION OF LOG IS PLANT SPECIFIC	PERIODIC AUDIT BY DESIGNATED HACCP TEAM PERSONNEL FOR ACCURACY AND COMPLETENESS OF DOCUMENTATION.
	BIOLOGICAL-MICROBIOLOGICAL CONTAMINATION	TRIMMING; OPERATIONAL SANITATION	CCP 7B	NO VISIBLE CONTAMINANTS	MONITORING WITH SUFFICIENT FREQUENCY BY DESIGNATED PLANT EMPLOYEE. RECORD OBSERVATIONS ON HACCP LOG.	NOTIFY APPROPRIATE PERSONNEL AND TAKE IMMEDIATE ACTION; EMPLOYEE TRAINING; DESIGNATED PLANT MANAGEMENT	DAILY DOCUMENTATION LOG MAINTAINED AND SIGNED BY DESIGNATED PLANT EMPLOYEE; LOCATION OF LOG IS PLANT SPECIFIC	PERIODIC AUDIT BY DESIGNATED HACCP TEAM PERSONNEL FOR ACCURACY AND COMPLETENESS OF DOCUMENTATION.

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March 31 - April 2, 1992

HAZARD ANALYSIS/PREVENTIVE MEASURES								
PRODUCT CATEGORY :		PORK SLAUGHTER MARKET HOGS						
WORKSHOP LOCATION :		MINNEAPOLIS, MN						
Process Step	Chemical Physical Biological Hazards	Preventive Measures	CCP	Critical Limits for Preventive Measures	Monitoring Procedures/ Frequency/ Person Responsible	Corrective/ Preventive Action/ Person Responsible	HACCP Records	Verification Procedure/ Person Responsible
	PATHOLOGICAL	RETAIN FOR VMO/USDA DISPOSITION/TRIM AND REMOVAL	CCP 7B	HANDLE AS DIRECTED BY USDA	MONITORING WITH SUFFICIENT FREQUENCY BY DESIGNATED PLANT EMPLOYEE. RECORD OBSERVATIONS ON HACCP LOG.	NOTIFY APPROPRIATE PERSONNEL AND TAKE IMMEDIATE ACTION; EMPLOYEE TRAINING; DESIGNATED PLANT MANAGEMENT	DAILY DOCUMENTATION LOG MAINTAINED AND SIGNED BY DESIGNATED PLANT EMPLOYEE; LOCATION OF LOG IS PLANT SPECIFIC	PERIODIC AUDIT BY DESIGNATED HACCP TEAM PERSONNEL FOR ACCURACY AND COMPLETENESS OF DOCUMENTATION.
HEAD REMOVAL	CHEMICAL -NONE							
	PHYSICAL -NONE							
	BIOLOGICAL - MICROBIOLOGICAL CONTAMINATION	OPERATIONAL SANITATION						
KIDNEY & LEAF FAT REMOVAL	CHEMICAL -NONE							
	PHYSICAL -NONE							
	BIOLOGICAL -NONE							
BRANDING	CHEMICAL -NONE							
	PHYSICAL -NONE							
	BIOLOGICAL -NONE							
FINAL WASH	CHEMICAL -NONE							
	PHYSICAL -NONE							
	BIOLOGICAL -NONE							
COOLER	CHEMICAL -NONE							
	PHYSICAL -NONE							

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March 31 - April 2, 1992

HAZARD ANALYSIS/PREVENTIVE MEASURES PRODUCT CATEGORY : PORK SLAUGHTER MARKET HOGS WORKSHOP LOCATION : MINNEAPOLIS, MN								
Process Step	Chemical Physical Biological Hazards	Preventive Measures	CCP	Critical Limits for Preventive Measures	Monitoring Procedures/ Frequency/ Person Responsible	Corrective/ Preventive Action/ Person Responsible	HACCP Records	Verification Procedure/ Person Responsible
OPERATIONAL SANITATION	BIOLOGICAL - MICROBIOLOGICAL CONTAMINATION	TIME/TEMPERATURE; PLANT SPECIFIC PROCEDURES	CCP 8B	PLANT SPECIFIC TIME/TEMPERATURE TO CONTROL MICROBIAL GROWTH	PLANT SPECIFIC TEMPERATURE CHECKS (CARCASS OR AIR) BY DESIGNATED EMPLOYEES. FREQUENCY DETERMINED BY PLANT. APPROPRIATE INFORMATION RECORDED AND SIGNED.	NOTIFY APPROPRIATE PERSONNEL, EVALUATE/ADJUST PROCESS AND/OR PRODUCT AS NEEDED. APPROPRIATE INFORMATION RECORDED AND SIGNED.	PLANT SPECIFIC MONITORING AND CORRECTIVE ACTIONS. RECORD ON FILE FOR PRE-DETERMINED TIME.	REGULAR AUDITS BY DESIGNATED PERSONNEL TO ASSURE COMPLIANCE WITH PROCEDURES, EQUIPMENT, CALIBRATION, AND RECORDKEEPING.
	CHEMICAL - NONE							
	PHYSICAL - NONE					NOTIFY APPROPRIATE PERSONNEL, EVALUATE/ADJUST PROCESS AND/OR PRODUCT AS NEEDED. APPROPRIATE INFORMATION RECORDED AND SIGNED.		
	BIOLOGICAL - MICROBIOLOGICAL CONTAMINATION	EMPLOYEE TRAINING; PERSONAL HYGIENE; SANITARY DRESSING PROCEDURES; PERSONAL CONCERNS.	CCP 9B	TRAINING PROGRAM WILL BE PROVIDED FOR ALL EMPLOYEES WHICH SHOULD INCLUDE PERSONAL HYGIENE, PRODUCT HANDLING PROCEDURES AND SANITARY DRESSING PROCEDURES	DOCUMENTATION OF EMPLOYEE TRAINING FOLLOWED BY PERIODIC OBSERVATION OF EMPLOYEE PRACTICES. RESPONSIBLE PERSONS/ FREQUENCY TO BE DETERMINED BY EACH PLANT. RESPONSIBLE PERSON WILL RECORD AND INITIAL.		DOCUMENTATION OF TRAINING FOR INDIVIDUAL EMPLOYEES RECORD. CCP LOG TO BE MAINTAINED FOR PERIOD SPECIFIED BY PLANT.	PLANT MANAGEMENT TO REVIEW RECORDS AND VERIFY HACCP PROCEDURES. FREQUENCY TO BE DETERMINED BY EACH PROCESSOR.

HAZARD ANALYSIS/PREVENTIVE MEASURES								
PRODUCT CATEGORY :		PORK SLAUGHTER MARKET HOGS						
WORKSHOP LOCATION :		MINNEAPOLIS, MN						
Process Step	Chemical Physical Biological Hazards	Preventive Measures	CCP	Critical Limits for Preventive Measures	Monitoring Procedures/ Frequency/ Person Responsible	Corrective/ Preventive Action/ Person Responsible	HACCP Records	Verification Procedure/ Person Responsible
		ENVIRONMENTAL CONCERNS	CCP 9B	PLANT SPECIFIC GMP'S TO MINIMIZE CARCASS CONTAMINATION	PERIODIC OBSERVATION OF FACILITY. RESPONSIBLE PERSONS/ FREQUENCY TO BE DETERMINED BY EACH PLANT. RESPONSIBLE PERSON WILL RECORD AND INITIAL.	IMMEDIATE CORRECTIVE ACTION TO INSURE CRITICAL LIMITS ARE MET TO INCLUDE: A.INSTRUCTING EMPLOYEE B.PREVENT CARCASS CONTAMINATION	CCP LOG TO BE MAINTAINED FOR PERIOD SPECIFIED BY PLANT.	PLANT MANAGEMENT TO REVIEW RECORDS AND VERIFY HACCP PROCEDURES.
PRE- OPERATIONAL SANITATION	CHEMICAL-CHEMICAL RESIDUE; EXCESSIVE SANITIZER CONCENTRATION	EMPLOYEE TRAINING; MIXING AND USE; CHECKING OF CORRECT CONCENTRATIONS; CORRECT PRE-RINSE	CCP 10C	PROPER TRAINING AND PROPER USE OF USDA APPROVED SANITATION CHEMICALS	DAILY VISUAL/SENSORY INSPECTION BY DESIGNATED EMPLOYEE. CHEMICAL TRAINING PROGRAM IN PLACE ROUTINELY MONITORED BY DESIGNATED EMPLOYEE. APPROPRIATE INFORMATION RECORDED AND SIGNED.	DEVIATIONS NOTED, APPROPRIATE PERSONNEL NOTIFIED, CORRECTIVE ACTION IMPLEMENTED AND APPROPRIATE INFORMATION RECORDED AND SIGNED.	PLANT SPECIFIC MONITORING AND CORRECTIVE ACTIONS. RECORD ON FILE FOR PRE- DETERMINED TIME.	REGULAR AUDITS AND/OR CHEMICAL TESTING BY DESIGNATED PERSONNEL TO ASSURE COMPLIANCE WITH PROCEDURES AND RECORDKEEPING.
	PHYSICAL-NONE							
	BIOLOGICAL - MICROBIOLOGICAL CONTAMINATION	VISIBLE CLEAN	CCP 10B	PLANT EQUIPMENT AND ENVIRONMENT MEETING SANITARY STANDARDS	DAILY VISUAL PRE-OP INSPECTION BY DESIGNATED EMPLOYEE. APPROPRIATE INFORMATION RECORDED AND SIGNED.	DEVIATIONS NOTED, APPROPRIATE PERSONNEL NOTIFIED, CORRECTIVE ACTION IMPLEMENTED AND APPROPRIATE INFORMATION RECORDED AND SIGNED.	PLANT SPECIFIC MONITORING AND CORRECTIVE ACTIONS. RECORD ON FILE FOR PRE- DETERMINED TIME.	REGULAR AUDITS AND/OR MICRO TESTING BY DESIGNATED PERSONNEL TO ASSURE COMPLIANCE WITH PROCEDURES AND RECORDKEEPING.

NOTE: THIS IS A DOCUMENT DEVELOPED AT THE INDUSTRY HACCP WORKSHOP FOR PORK SLAUGHTER (MARKET HOGS). IT DEMONSTRATES THE METHODOLOGY USED TO DEVELOP THE GENERIC INDUSTRY HACCP MODEL.
March 31 - April 2, 1992

**HACCP STEERING COMMITTEE
(SWINE SLAUGHTER (MARKET HOGS))**

<p style="text-align: center;"><u>CHAIRPERSON</u></p> <p>KATIE HANIGAN MANAGER, ANALYTICAL SERVICES FARMLAND FOODS INDUSTRIAL DRIVE DENISON, IA 51442</p> <p>(712) 263-7383</p>	<p style="text-align: center;"><u>CO-CHAIRPERSON</u></p> <p>ELLEN L. GRABER QUALITY CONTROL MANAGER THORN APPLE VALLEY 1487 FARNSWORTH DETROIT, MI 48211</p> <p>(313) 832-6080</p>
<p>PAUL T. CONNER DIRECTOR, PRODUCT CONTROL PORK DIVISION IBP P.O. BOX 515, HWY. 35 DAKOTA CITY, NE 68731</p> <p>(402) 241-3105</p>	<p>KIRK JONES DIRECTOR, PRODUCT INTEGRITY AND FOOD SAFETY, PORK DIVISION MONFORT, INC. P.O. BOX G GREELEY, CO 80632</p> <p>(303) 353-2311</p>
<p>BOB NEUBAUER PLANT COORDINATOR JOHNSONVILLE FOODS 104 DIVISION STREET WATERTOWN, WI 53094</p> <p>(414) 261-1870</p>	

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